

Ship Nov. 01

Work Order ID 152672

152672

Page 1

Thursday, November 03, 2016 3:35:37 PM

Item ID: D5393-043 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Strut Weldment

Start Date: 11/3/2016 Start Qty: 1.00 *1*

Required Date: 11/8/2016 Req'd Qty: 1.00 *1*

Reference: Cust Item ID:

Customer:

Approvals: Process Plan: [Signature] Date: 16-11-03 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5393	A

110 Weld per dwg A/R S.S. rod Batch: M134442 0.00

110

Large Fab

Memo

0.14

Large Fab

Weld stud to strut as per dwg

GRIND WELD FLUSH

1 16-11-7

120

QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

16-11-07 ①

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

1 16-11-07 23

DQA: 11 Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: <u> </u> Part No. <u> </u> NCR No. <u> </u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :				
Misidentified ☐	Past Due ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 152672

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Item ID: D5393-043 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 11/3/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/8/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02							
Quality Control									

DAS
21
9-09 NOV 07 2016

16-11-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																														
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="4" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td>Environment ☐</td> <td>☐ No Re-verification</td> <td>☐ Pressure/Forced</td> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>Design ☐</td> <td>☐ Operator</td> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>Doc/Data ☐</td> <td>☐ Offset/Setup</td> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>☐ Supplier</td> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>☐ Training</td> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>Material ☐</td> <td>☐ Use for Testing</td> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>Internal Transport ☐</td> <td>☐ Poor Information</td> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>☐ Rushing</td> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>LOA ☐</td> <td>☐ Product Improvement</td> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>Substation ☐</td> <td>☐ Process Improvement</td> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>☐ Manufacturing Process</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: middle;">OTHER :</td> </tr> <tr> <td>Misidentified ☐</td> <td>☐ Past Due</td> </tr> </tbody> </table>						Root Cause			FAULT CATEGORY				Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	Past Expiry Date ☐	☐ Manufacturing Process	OTHER :				Misidentified ☐	☐ Past Due
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Picklist Print

Thursday, November 03, 2016 3:35:44 PM

Page 1

Work Order ID: 152672

152672

Parent Item: D5393-043

D5393-043

Parent Item Name: Strut Weldment

Start Date: 11/3/2016

Required Date: 11/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.02.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4794-3		Manufactured	No				Each	13.0000		2			
D4794-3									**				
Stud													

Location	Loc Qty	Loc Code
WA001	13	
137047	2	
145967	11	

D5393-1		Manufactured	No				Each	0.0000		1			
D5393-1									**				
Strut													

152 674 X 1

AN665-34R		Purchased	No				Each	33.0000		2			
AN665-34R									**				
Clevis													

Location	Loc Qty	Loc Code
ST330	33	
M135603	13	
M135948	20	

NAS509-4C		Purchased	No				Each	9.0000		2			
NAS509-4C									**				
NUT													

Location	Loc Qty	Loc Code
ST551	9	
M134567	4	
M134676	5	

DAS
30
9-89

NOV 07 2016

DAS
30
9-89

NOV 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

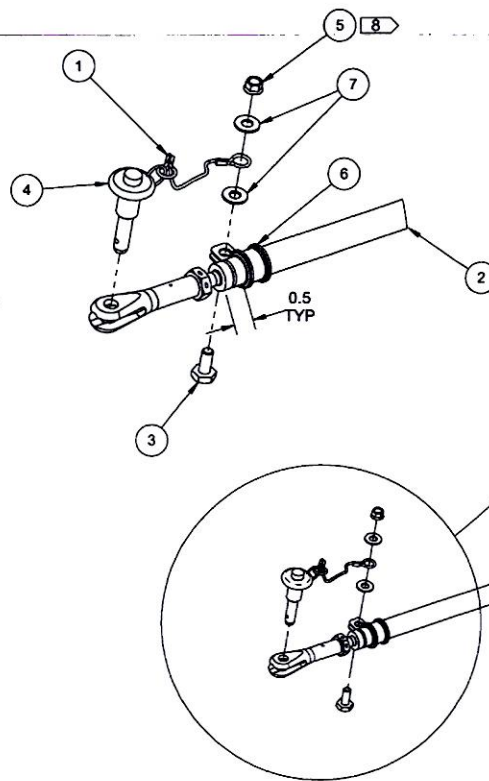
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

DETAIL A
(TYP)



D5393-041 STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE NUTS TO 20-25 in-lb

ITEM	QTY	P/N	DESCRIPTION
	X	D5393-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5393-043	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	MS17984-C405	PIN, QUICK RELEASE
5	2	MS21043-3	NUT, SELF-LOCKING
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152672
MP16-11-03

RELEASE
2016-02-08
ECN 520

APPROVED

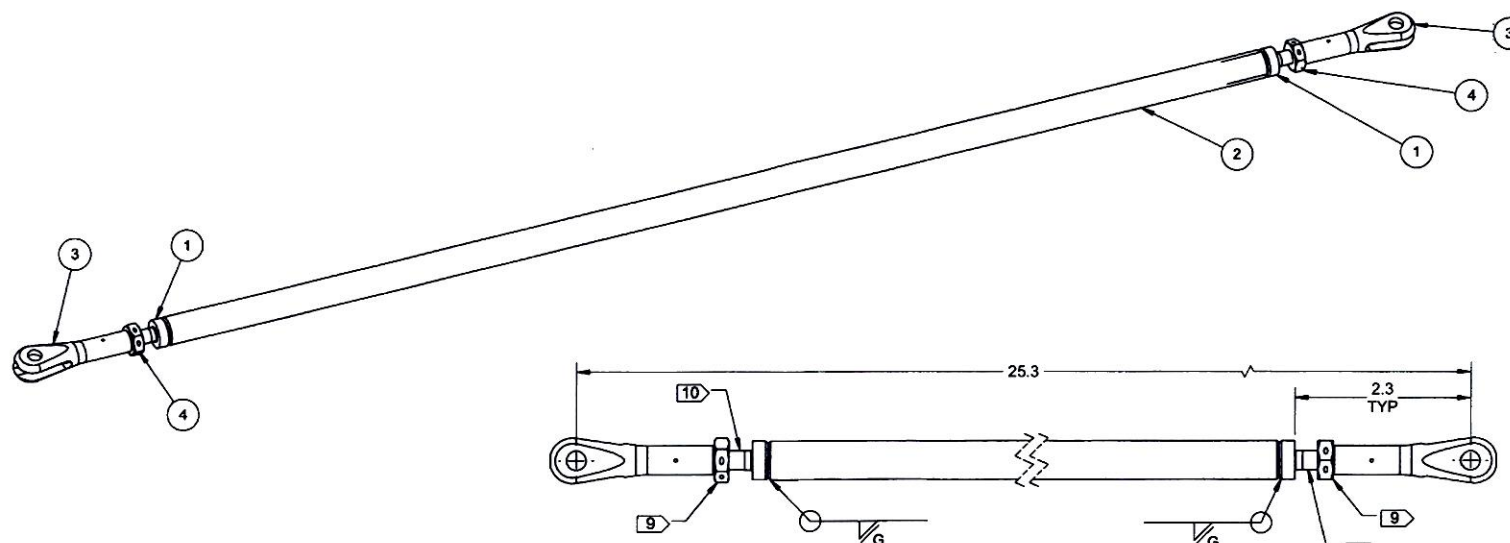
A	NEW ISSUE	RF	16.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	16.01.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D5393
REV. A
SHEET 1 OF 3
SCALE NTS
TITLE STRUT ASSEMBLY

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D5393-043	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5393-1	STRUT
3	2	AN665-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5393-043 STRUT WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

RELEASED
2016-02-08

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5393	REV. A
MFG. APPR.	DD		SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	16.01.27	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

0.030 x 45°
CMF, 2 PL

Ø

20.40

D5393-1 STRUT

Ø0.500
REF

0.049
REF

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF. DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs

RELEASED
2016-02-08

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5393	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	16.01.27	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1